



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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D4776-1
Job Sheet 197673



Part No: D4776-1

Job Qty: 28 pcs

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/12/19

Job Tracking No:

Due Date: 8/19/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG D4776 REV.E IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	28 pcs	8/19/19	8/19/19	0.54	14.89	Doosan - 1		JRD 19/08/20
105	QC 2	28 pcs	8/19/19	8/19/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		JRD 19/08/20
							QC 2 - 6		
							QC 2 - 71		
							QC 2 - 73		
							QC 2 - 69		
111	QC 8	28 pcs	8/19/19	8/19/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		

						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	2021 19/08/21
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
112 Handfinish - 1-1 Chemical-B4B	28 pcs	8/19/19	0.00	0.80		Handfinish - 1 - 1 - B4B	BEB19-08-21
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
113 QC 7	28 pcs	8/19/19	0.00	0.00		QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	

				QC 7 - 30	BL 19-801
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
115 Powdercoat - 1 - White GI(A)-	28	8/19/19	0.00 0.32	Powdercoat - 1 - B4B	BL 198-01
B4B M193459.	pcs			Powdercoat - 2 - B4B	
START: 3:40. O.V.T. 3:00 FINISH: 4:10				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
116 QC 3	28	8/19/19	0.00 0.00	QC 3 - 10	DAS AUG 22 2019 40 9-80
	pcs			QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
130 Packaging 3-1 - Stock - B4B	28	8/19/19	0.00 0.00	Packaging 3 - 1 - B4B	NL ST114
	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 -	

					B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	28 pcs	8/19/19	0.00	0.00	QC 21 - SA - 21
						QC 21 - SA - 70
						QC 21 - SA - 53
Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FB167 Rev: AA & Dwg D4776 Rev: E 2 -Deburr per dwg D4776						
Descriptions: 105 - (QC2- Inspect parts off machine FAI/FAIB)						
111 - (QC8- Inspect parts - second check)						
112 - (Chemical Conversion Coat per QSI005 4.1)						
113 - (QC7-Inspect Chemical Conversion Coat)						
115 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) MASK .403 ROUND SECTION AS PER DWG START TIME:						
OVEN TEMPERATURE: FINISH TIME:						
116 - (QC3- Inspect Part Finish)						
130 - (Identify as per dwg & Stock Location:)						
140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M6061T6R1.500	6061-T6 Round Bar 1.50	9.5480 ft (.341 ea)	100-Doosan - 1	3188585		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Doosan - 1	M6061T6R1.500	10	20	0		

AUG 23 2019
DAS
70
9.89

DAS
77
9-89

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850		
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428		
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350		
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615		
5	Basket Strut Clevis	1.750Inches ± 0.030	1.780 1.720		
6	Basket Strut Clevis	3.500Inches ± 0.030	3.530 3.470		
7	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle	
8	Basket Strut Clevis	0.030Inches ± 0.030	0.060 0.000		
9	Basket Strut Clevis	0.060Inches ± 0.030	0.090 0.030	Radius	
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter	
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter	
12	Basket Strut Clevis	0.410Inches ± 0.030	0.440 0.380	Radius	
13	Basket Strut Clevis	1.130Inches ± 0.030	1.160 1.100		
14	Basket Strut Clevis	0.188Inches ± 0.010	0.198 0.178		
15	Basket Strut Clevis	0.190Inches ± 0.030	0.220 0.160		
16	Basket Strut Clevis	0.500Inches ± 0.030	0.530 0.470		
17	Basket Strut Clevis	0.750Inches ± 0.010	0.760 0.740		
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter	
19	Basket Strut Clevis	0.130Inches ± 0.030	0.160 0.100	Radius	
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750		
21	Basket Strut Clevis	0.160Inches ± 0.030	0.190 0.130		
22	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle	

Plex 7/12/19 12:36 PM Dart.Renwick.Jennifer

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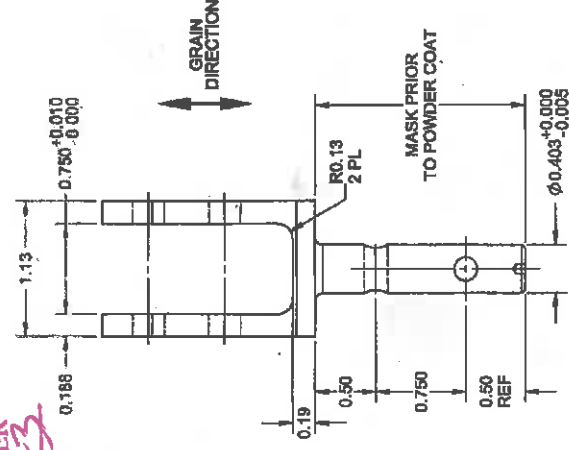
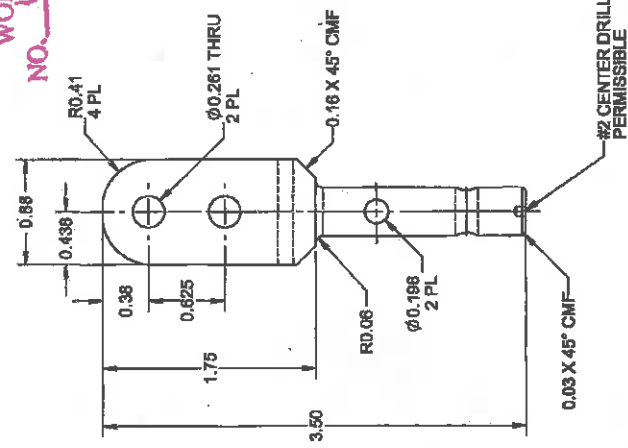
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WITHOUT NOTICE

WORK ORDER

NO 197673

~~SECRET~~



RELEASED
2018-12-03
BY 114-04

D4776-1 BASKET STRUT CLEVIS

E	REVIS. 3 PER TR-0350-407-4 STRUCTURAL TEST INPUTS	RF	18.08.12
D	SWT 1, C3 CHAMFER, J2 RIB, SEE PAR. 14.38.3, BUT 2 SWT 2, C3 CHAMFER, J2 RIB, SEE PAR. 14.38.3, BUT 2 DIM. CORRECTED TO 0.35 DUE TO DESIGN ERROR (SEE PAR. 14.38.2).	AJS	14.07.14
C	SWT 2, C7, 1.15 DIM WAS 0.89, C3.899 WAS 0.438, 2 TOW VIEW WITH CHAMFERS, REASON: INTERFERENCE WITH CERN SANDPAPER.	AJS	12.10.31
B	INSTALLATION OF NEW FASTENERS, INDEX OF HOLES ON THE STEM OF 1, ROTATED 90°, FINISH ADDED TO 1, TOE OF SCREW WAS NOT FILL 1, C3, 1.15 DIM. ADDED. TOE OF SCREW EASE OF INSTALLATION, C32. DEPTH DIM. ADDED.	AJS	13.08.14
A	NEW ISSUE	AJS	12.03.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	RF		
CHECKED	VS		
MFG. APPR	JFS		
APPROVED	VS		
DE APPR.	DSW <i>DSW</i>		
DATE	18.09.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4776**

REV. E E

SHEET 1 OF 3

SCALE

BASKET STRUT MACHINED PARTS NTS

COMPONENT 2 OF 3 DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
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AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART
AEROSPACE LTD.

NOTES:

- 1) MATERIAL: 8091-T8785/1765/107561/1762 ALUMINUM BAR
PER QCA-A-225/8 OR AMS-QCA-225/6
OR AMS 4117/4128/4154/4161
OR QCA-A-200/8 OR AMS-QCA-200/8 (OR AMS 4190)
OR ASTM B211 OR ASTM B221
REF PART SPEC M0061T03
- 2) FINISH: CHEMICAL CONVERSION COAT PER PART QSI 005 4.1
POWDER COAT WHITE (4.3.6.1) PER PART QSI 005 4.3
- 3) TOLERANCES: PER PART QSI 011.18 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs